

split

Dart Aerospace Ltd.

Scrapped

Date: Tuesday, 15/08/2006 2:19:21 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FOLDING STEP WELDMENT LH
Job Number : 28198	
Estimate Number : 10463	
P.O. Number :	Part Number : D3388041
This Issue : 15/08/2006 S.O. No. :	Drawing Number : D3388 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27272	Material :
Written By : <u>W</u>	Due Date : 22/08/2006 Qty: 4 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est. B 05.06.10 Added Step 11 KJ/JLM Est Rev:C Revised Steps 06-06-14 JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

D2622-120C extrusion 8

Batch: 327072

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388

2-Deburr and bevel ends for welding

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

206 Step Endplate

Pick:

Qty

Part Number

Description

Batch

2

D2734

End Cap

327231

4.0

D33871

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Arm

Pick:

Qty

Part Number

Description

Batch

2

D3387-1

Arm

327104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and fwd end cap as per Dwg D3388.

A/R AL ROD Batch: M100660

Dwg Rev: A

2-Grind end cap welds flush

*P.E. 06-08-16* 4  
*P.E. 06-08-16* 4

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*P.E. 06-08-16 (4)*

*M06/08/16 (4)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 06-08-16 (4)*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign objects as per QSI 024.

2-Weld last end cap as per Dwg D3388.

A/R AL ROD Batch: M100660

Dwg Rev: A M15689

2-Grind end cap welds flush

*P.E. 06-08-22* 4  
*P.E. 06-08-22* 4  
*P.E. 06-08-22* 4  
*P.E. 06-08-22* 4

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*P.E. 06-08-23 (4)*

*M06/08/29 (4)*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical conversion.

*A.M. 06-08-30* (4)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

G.m

06-08-29

(4)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

a.m

06-08-30

3-split copy  
1-keep

(4) P7C

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



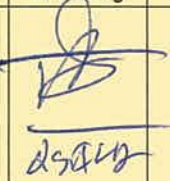





SCVAD  
2007/7

W 27/07/07



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3388 04 PAR #: N/A Fault Category: ENG - DESIGN NCR: Yes ☒ No ☐ DQA: AS Date: 07.07.17  
 QA: N/C Closed:        Date:       

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		<del>12 took one Ser</del> <del>eng</del>						
07/07/17	13.0	Step is no more good, and does not have a mate, due to new drawing for a better step.		Scrap: destroy any ①		07/07/17		

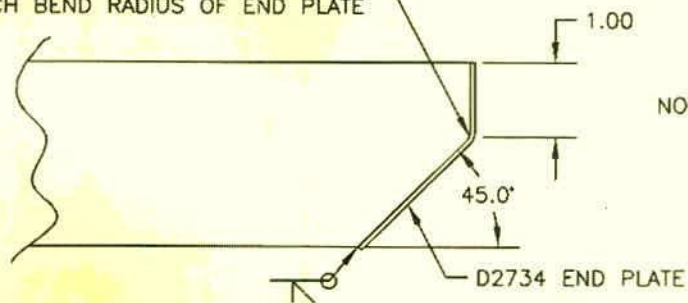
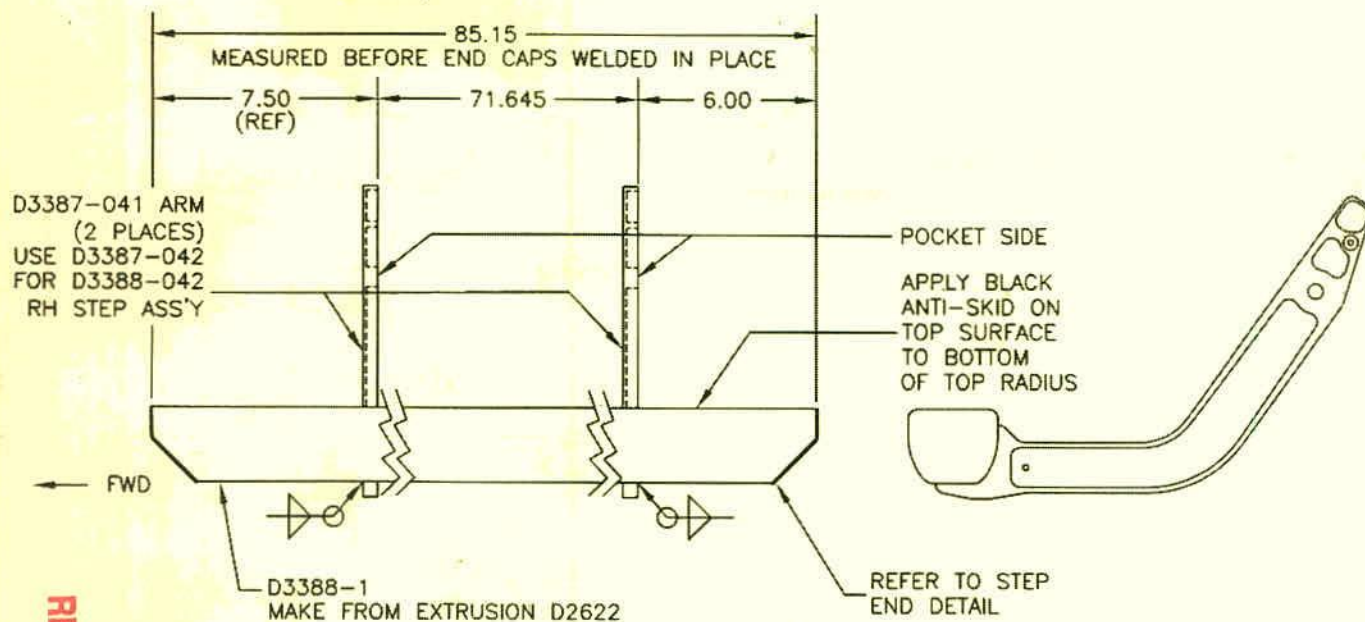
NOTE: Date & initial all entries



**DART**

RELEASED

05 03 1

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATENOTE: ALL WELDS SHALL BE 100%  
VISUALLY INSPECTED BY A  
QUALIFIED INSPECTOR PER  
DART QSI 004TYPICAL STEP END DETAIL  
NOT TO SCALED3388-041 LH STEP ASSEMBLY (SHOWN)  
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

**REFERENCE ONLY**

DESIGN	DRAWN BY	DART AEROSPACE LTD
05 03 1	05.01.20	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.01.20	05.01.20	D3388
DATE	TITLE	STEP WELDMENT
A	NEW ISSUE	SCALE
		NTS

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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